



Filament Data Sheet

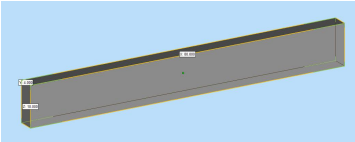
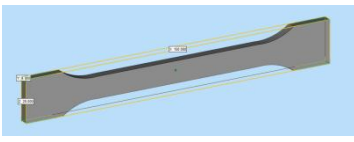
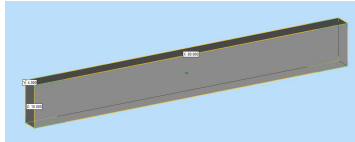
PLA-F(Force)

Revision Date:25/12/2025

Application: FDM

Version: 01

RECOMMENDED PRINTING CONDITIONS	
Nozzle Temperature	210-240°C
Bed Temperature	20-60°C
Closure Chamber	Recommended open printing
Drying Setting	55°C for 6H

FLEXURAL TESTING SPECIMEN	TENSILE TESTING SPECIMEN	IMPACT TESTING SPECIMEN
ISO 178/T 9341	ISO 527,GB/T 1040	ISO 180,GB/T1043
		

PHYSICAL PROPERTIES				
Performance	Condition	Standards	Unit	Values
Density	25°C	ISO 1183	g/cm ³	1.072
Melt Flow Rate	220°C/2.16kg	ISO 1133	g/10min	5.76

MECHANICAL PROPERTIES				
Performance	Condition	Standards	Unit	Values
TensileStrength (X-Y)	10*4mm sample	ISO 527-2	MPa	32.72
TensileStrength (Z)	10*4mm sample	ISO 527-2	MPa	9.72
Elongation at break (X-Y)	10*4mm sample	ISO 527-2	%	14.56
Elongation at break (Z)	10*4mm sample	ISO 527-2	%	8.18
Bending modulus(X-Y)	10*4mm sample	ISO178	MPa	1092.67
Bending modulus(Z)	10*4mm sample	ISO178	MPa	755.37
Bending strength (X-Y)	10*4mm sample	ISO178	MPa	43.16
Bending strength (Z)	10*4mm sample	ISO178	MPa	12.92
Notched impact strength (X-Y)	10*4mm sample notched	ISO180	KJ/m ²	25.9
Notched impact strength (Z)	10*4mm sample notched	ISO180	KJ/m ²	2.81
Non-notched impact strength (X-Y)	10*4mm sample non notched	ISO180	KJ/m ²	45.92
Non-notched impact strength (Z)	10*4mm sample non notched	ISO180	KJ/m ²	4.14

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